

Date: Tuesday, 01/04/2008 12:42:09 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 38273		
Estimate Number	: 10512		
P.O. Number	:	Part Number	: D26511
This Issue	: 01/04/2008 S.O. No. :	Drawing Number	: D2651 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 33349	Material	:
Written By	: <i>J. F. 08.04.07</i>	Due Date	: 08/04/2008 Qty: 500 Um: Each
Checked & Approved By	:		
Comment	: Est. A 02.04.15 New Issue NG		
	: Est. B 05.12.12 added deburr EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0421 f(s)/Unit Total: 21.0525 f(s)

Material: 6061-T6 (QQ-A-225/8) 0.500" Dia

(M6061T6R0500)

Batch: *M105671**J.F. 08/04/07 (570)*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Turn as per Folio FA219 and Dwg D2651

2- Deburr

J.F. 08/04/07 (570)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/04/07 (570)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

29 08/04/07 (570)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr ias per dwg D2651

N/A J.F. 08-05-07

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 38273

Part Number: D26511

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

FL 08/04/07 (570)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Only larger section necessary)

M107550
M-L/BL 08/04/09 (570X)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

FL 08/04/09 (570)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

FP 1
M-L 08/04/09 (570X)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/04/10

Job Completion



U 8.04.10

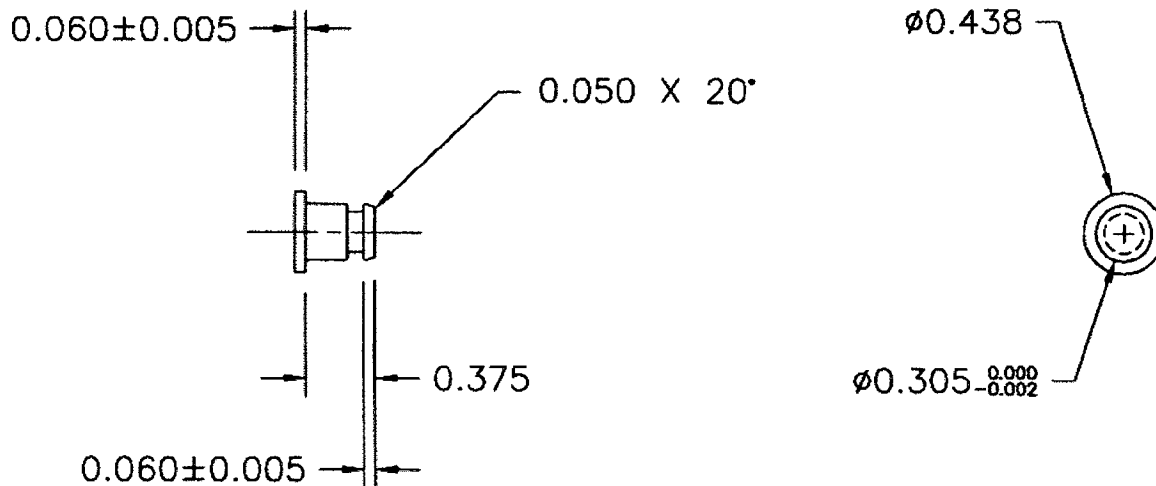


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. 8 SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

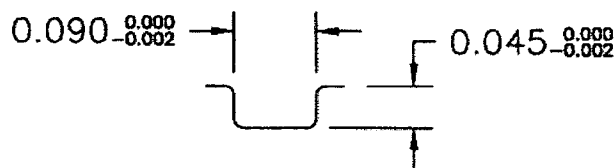
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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